

Date: Thursday, 22/01/2009 7:54:11 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STABILIZER ARM
Job Number	: 45025		
Estimate Number	: 13523		
P.O. Number	:	Part Number	: PB674300157
This Issue	: 22/01/2009 S.O. No. :	Drawing Number	: B6743001 P.13
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 41382	Material	:
Written By	:	Due Date	: 28/01/2009 Qty: 9 Um: Each
Checked & Approved By	: <u>UMF 09-01-22</u>		
Comment	: Est Rev:A 08-07-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001111	Tube End Plate
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lala land



Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Tube End Plate

batch: 1 X 40013, 8 X 41476

UMF 09-02-12

2.0	PB6743001107	Tube Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Tube Arm

batch: 2 41474

UMF 09-02-12

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 1-Weld assembly as per dwg PB67-43001

SP 09-02-17 (9X)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

09-02-17 (9)

5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

RE 09-02-17 (9X)

6.0	PB6743001109	Male Eye
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Male Eye

batch: ~~1415~~ 323087B=3
341475=6

09-02-24 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 7:54:11 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STABILIZER ARM

Job Number: 45025

Part Number: PB674300157

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 18.0000 Each(s)

SPRING SLOTTED PIN

batch: M17850

PK 09.02.24 9

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- line drill -107 and -109 using existing pilot hole of -107 as per dwg

2- install spring pin

*709-323927B
3-11415*

PK 09.02.24 9

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/24 GS

PTO

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: 10:00AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 10:30AM

MS 09-02-27

X8

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PK 09-03-02

9

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 437

MF 09-03-06

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PK 09/03/06

9

Job Completion,



MF 09-03-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/03/03	10.0	start time: 1:15 Temperature: 320° Finish time: 1:45 Powder coated 1 arm that was forgotten last time.	FD	09/03/03	(1)		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

